

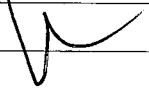
Work Order ID 123167

July-30-14 7:28:30 AM

123167

Page 1

Item ID: D2916-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cable Guard, 212 Skidtube
 Start Date: 7/30/14 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 8/08/14 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2916	Rev D								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2916 Dwg Rev: 0 Prog Rev: 0 2-
 Deburr if necessary
 OHMW 1" DAS 23 9-89 14-07-30

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control DAS 23 9-89 14-07-30

120 0.00
120 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 BATCH: _____ 1- Mill as per Folio FB077 Rev: AA
 & Dwg D2916 Rev: 0 2-Deburr per dwg D2916 DAS 20 9-89 14-08-24

Work Order ID 123167

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Page 2

Item ID: D2916-5

Revision ID:

Item Name: Cable Guard, 212 Skidtube

Start Date: 7/30/14 Start Qty: 8.00

Required Date: 8/08/14 Req'd Qty: 8.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC2- Inspect parts off machine FAI/FAIB	0.00				8	0		DAS 20 9-89 14-08-24
130									
QC	Memo	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00				8	0		DAS 37 9-89 14-08-25
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									14/8/25 (P) DAS 32 9-89

Work Order ID 123167

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123167

Page 3

Item ID: D2916-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cable Guard, 212 Skidtube
 Start Date: 7/30/14 Start Qty: 8.00 *g* Cust Item ID:
 Required Date: 8/08/14 Req'd Qty: 8.00 *g* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 14-08-25
MLJ 14-08-25

Picklist Print

July-30-14 7:28:29 AM

Page 1

Work Order ID: 123167

123167

Parent Item: D2916-5

D2916-5

Parent Item Name: Cable Guard, 212 Skidtube

Start Date: 7/30/14

Required Date: 8/08/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-06-19 JLM
IPP Rev:B Now water jet 06-07-14 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MUHMWB10		Purchased	No			100	sf	432.0000	0.4	4			DAS
----------	--	-----------	----	--	--	-----	----	----------	-----	---	--	--	-----

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

23
9-89 1407-30

Location

Loc Qty

Loc Code

MAT014

432

m128267

47

m128668

313.3

m129293

71.7

129293

FIRST ARTICLE INSPECTION CHECKLIST

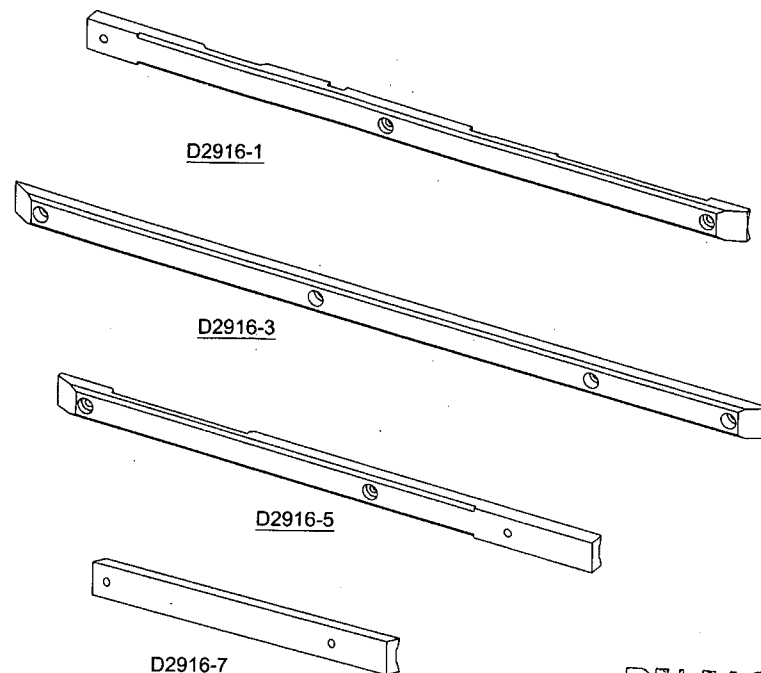
Measured by: 9-89	Audited by: 37 9-89	Preliminary Approval:
Date: 14-08-24	Date: 14.08.25	Date:

H:\FORMS\Quality Assurance\approved QA\FAI Rev B

W/O
123167

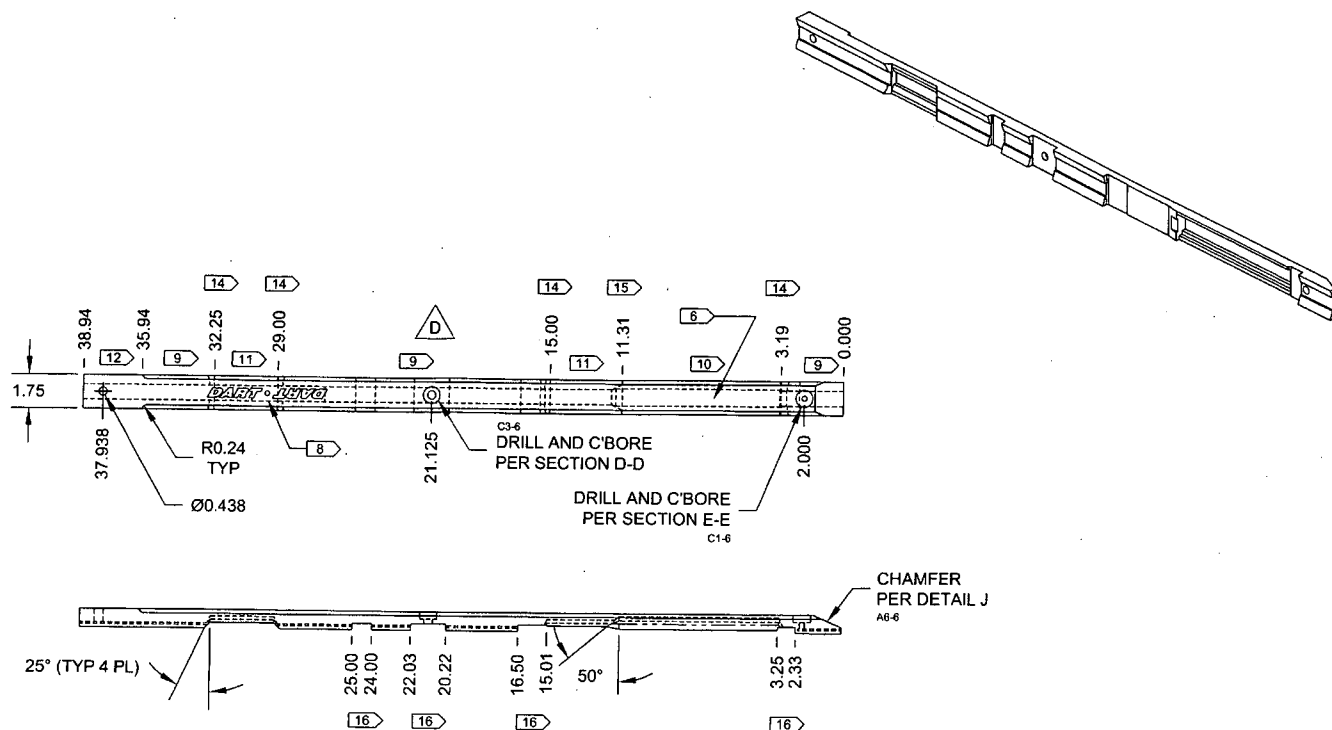
NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMB10
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED RADII 0.020 TO 0.040
- 6) IDENTIFICATION: ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010
- 7) WEIGHT:
 - D2916-1 = 1.37 lbs
 - D2916-3 = 2.33 lbs
 - D2916-5 = 1.19 lbs
 - D2916-7 = 0.96 lbs
- 8) ENGRAVE TWO DART LOGOS (OPPOSITE AS SHOWN) ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250
- 9) MACHINE CONSTANT SECTION A-A
- 10) MACHINE CONSTANT SECTION B-B
- 11) MACHINE CONSTANT SECTION C-C
- 12) MACHINE CONSTANT SECTION F-F
- 13) MACHINE CONSTANT SECTION G-G
- 14) 25° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 15) 50° ANGLE OF TRANSITION BETWEEN SECTIONS WITH MIN RADIUS OF 0.50
- 16) MACHINE SLOT WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS
- 17) ALL HOLES DRILLED ON CENTERLINES



RELEASE
R 2011-11-02
MP

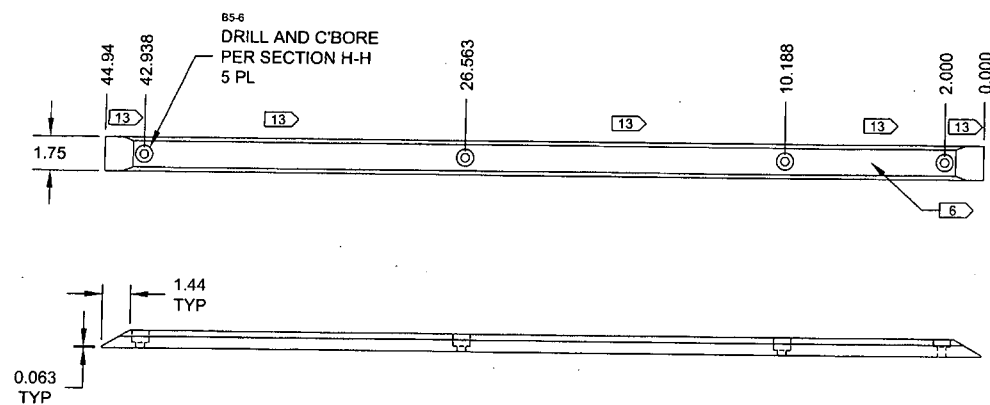
D	REVISE MACHINE SLOT. (ZN C5-2, C4-4, C4-5, C6-5) REVISE SECTIONS D-D, L-L, N-N	RF	11.10.07
C	REVISE D-D; ADD L-L, M-M & N-N; FOR D4406-041/-043 COMPATIBILITY	RF	11.08.17
B	ADD K-K FOR D2521 COMPATIBILITY	CP	00.02.24
A	NEW ISSUE	CP	99.09.29
REV.	DESCRIPTION	BY	DATE
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D2916-1

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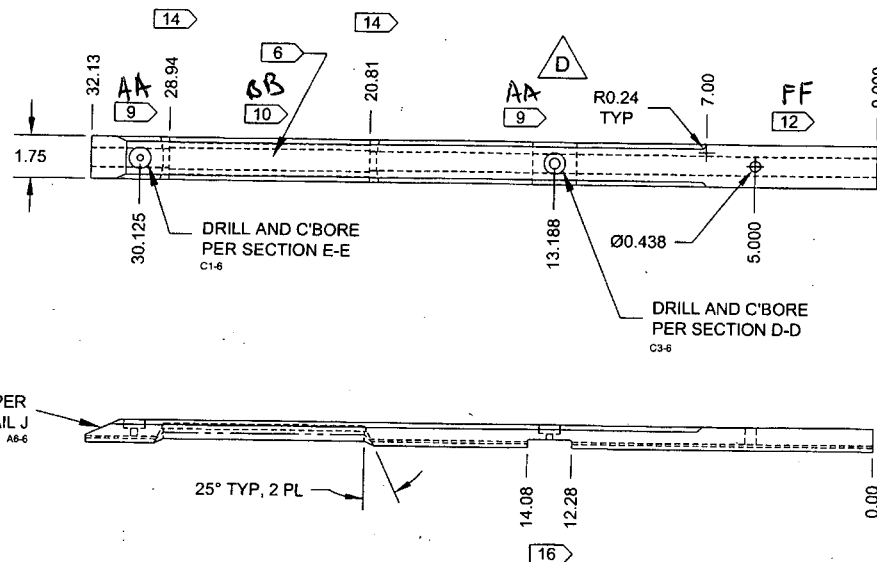
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D2916-3

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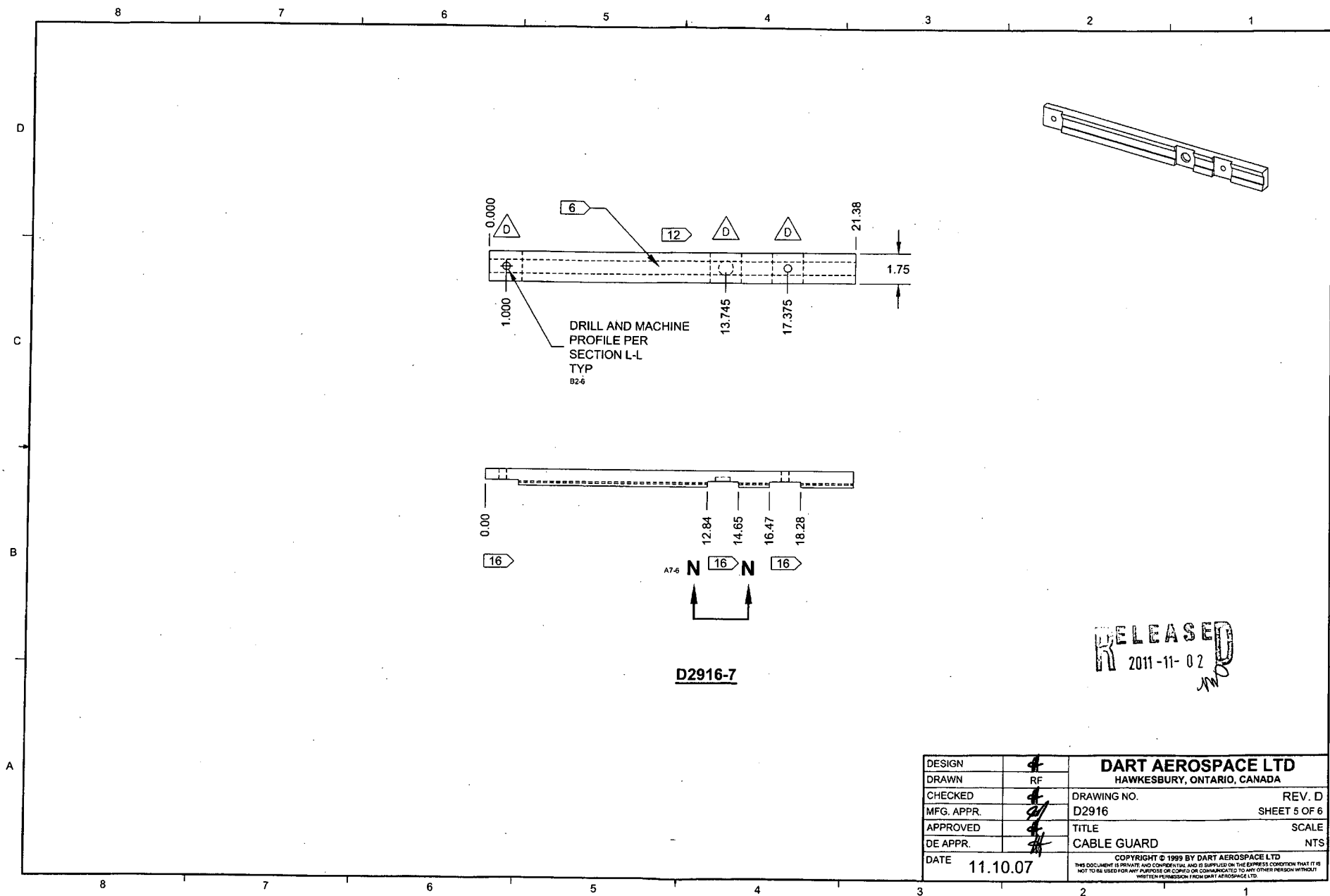
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D2916-5

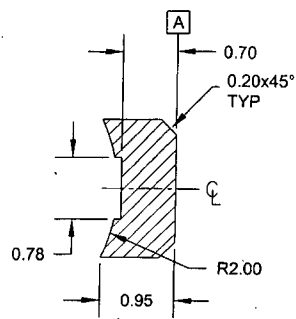
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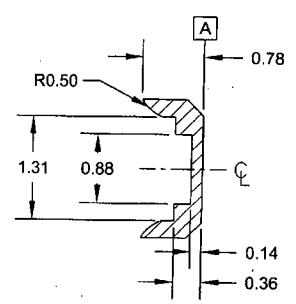


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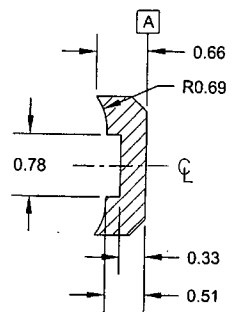
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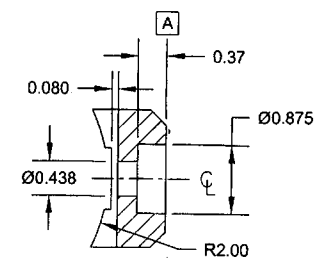
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C3-2
C6-2
C4-4
C6-4



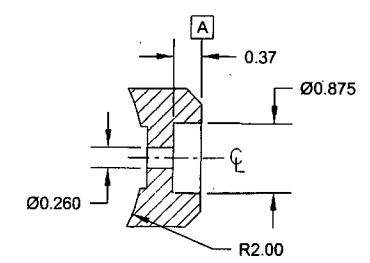
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C5-4



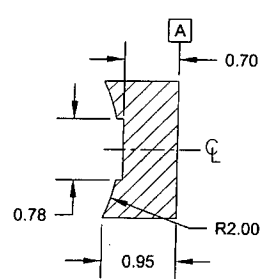
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C4-2



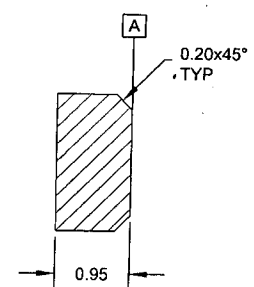
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SCALE 4X
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C3-4



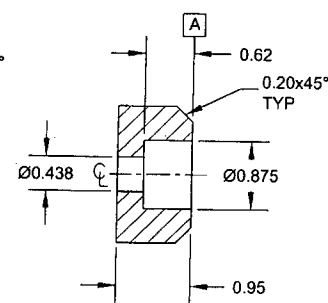
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SCALE 4X
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C5-4



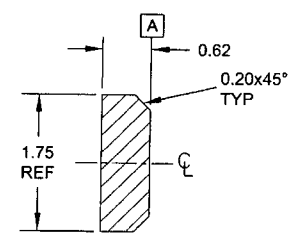
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SCALE 4X
C6-2
C3-4
C5-5



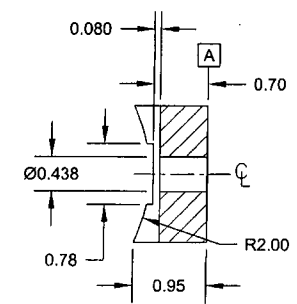
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SCALE 4X
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C4-3
C5-3
C6-3
C7-3



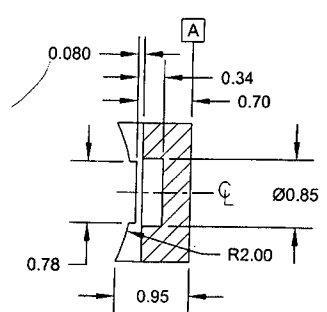
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C6-3



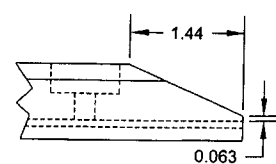
SECTION K-K
SCALE 4X
B3-2
B4-2
B5-2



SECTION L-L
SCALE 4X
C5-5



SECTION N-N
SCALE 4X
B6-5



DETAIL J
SCALE 4X
B3-2
B7-4

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